

Date: Tuesday, 25/11/2008 2:05:29 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 43727		
Estimate Number	: 10672		
P.O. Number	:	Part Number	: D29703
This Issue	: 25/11/2008 S.O. No. :	Drawing Number	: D2970 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 41677	Material	:
Written By	:	Due Date	: 02/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>UMF 08-11-25</u>		
Comment	: Est: B 01.06.07 Added Material and Tool number SM/EC est C 08.09.03 Waterjet EC verified: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2970

Dwg Rev: AProg Rev: A

IB 8-11-26

(12)

2-Deburr if necessary

IB 8-11-26

2.0	M1010S 209A 209A	1010/1025 SHEET .040
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Comment: Qty.: 1.3125 sf(s)/Unit Total: 13.1250 sf(s)

1010/1025 SHEET .040

batch: 107906

IB 8-11-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-11-26

4.0	QC8	SECOND CHECK
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Comment: DIMENSIONAL CHECK

S 08/11/26

(12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970

S 08/11/26 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 25/11/2008 2:05:29 PM
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Drawing Name: WEARPLATE

Job Number: 43727

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26 (12)

7.0

POWDER COATING

POWDER COATING



M109648



(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:40
320°F
2:10

M- 08/11/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F2 08/11/26 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-21

F2 08/11/26 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/27

Job Completion



MF 08-11-26

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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GA COPY ISSUED

DESIGN 21	DRAWN BY 71-	DART AEROSPACE USA, INC. BELLEVUE, WA	REV. A
CHECKED [Signature]	APPROVED [Signature]		DRAWING NO. D2970
DATE 00.03.10	TITLE WEARPLATE	SHEET 1 OF 1	SCALE 1:10
A	00.03.10	NEW ISSUE	

00-000000

0.220 x 0.300
OBROUND

0.375

RO.375

RO.375

The drawing shows a circular part with a central hole. The overall dimensions are 0.220 x 0.300, and the part is described as 'OBROUND'. A dimension of 0.375 is shown for the distance from the center to the outer edge. The radius of the outer edge is labeled as RO.375. A cross-section is indicated by a circle with a cross inside.

A technical drawing showing a curved surface, likely a part of a mechanical component. The curve is defined by a radius dimension labeled $R1.77$. The drawing includes a centerline and a dimension line with arrows pointing to the curve.

REFERENCE ONLY

Technical drawing of a shaft assembly. The drawing shows a shaft with a central hole and a keyway. The overall length is 17.400. The distance from the left end to the center of the hole is 5.800 (TYP). The distance from the center of the hole to the right end is 2.063 (REF). The shaft has a diameter of 2.813. The keyway has a width of 0.375 (TYP). The shaft is labeled with R0.13 (TYP). A detail A is indicated by a leader line pointing to the keyway.

D2970-3 BENDING DETAIL

A technical drawing showing a cross-section of a beam. The beam has a central vertical crack and a horizontal crack. The beam is labeled 'B' at both ends.

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER: DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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